

Work Order ID 62017

Wednesday, September 15, 2010 10:00:04 A



Page 1

Item ID: D3763-045

Accept



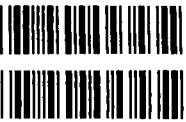
Setup Start



Revision ID:

Item Name: End Fitting Assembly

Stop



Start Date: 9/14/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-9-15 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3763	Rev B

100



Pick Kit

0.00



Packaging

Memo

0.00

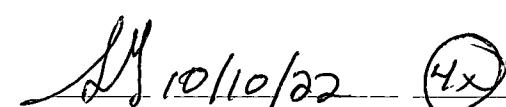
Packaging

110



Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-make a 0.063" chamfer on D3763-1 fitting before ass'y 2-assemble and tack weld as per dwg D3763 using locating pin DT9039 ***remove pin before welding*** 3-weld as per dwg D3763 , QSI004 Alum. rod
Batch: M112860

120



QC9- Inspect visual per QSI004- Fusion Welds

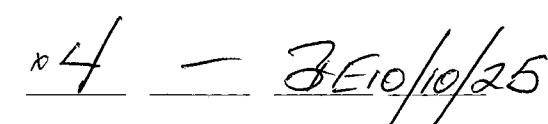
0.00

QC

Memo

0.00

Quality Control



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3763-045

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Setup Start



Revision ID:

Item Name: End Fitting Assembly

Stop



Start Date: 9/14/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S 10/10/25

(4)

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

BK 10-10-26.

(4)

Hand Finishing

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

=> M 10/10/25

(4) O

W/O:		WORK ORDER CHANGES					
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Wednesday, September 15, 2010 10:00:04 A



Page 3

Item ID: D3763-045

Accept



Setup

Start



Revision ID:

Item Name: End Fitting Assembly

Stop



Start Date: 9/14/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: 251A

0.00

10/10/26 (4)

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/26 (4)

*MF**10-10-26*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 15, 2010 10:00:07 AM

Page 1

Work Order ID: 62017



Parent Item: D3763-045



Parent Item Name: End Fitting Assembly

Start Date: 9/14/2010

Required Date: 9/21/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-18 new issue DD verified by:ec
IPP Rev:B 08-08-11 add chemical coat and qc3 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3763-7 		Manufactured	No			100	Each	10.0000	1	4		<i>SM 10/10/22</i>	
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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3763-7 		Manufactured	No			100	Each	10.0000	1	4		<i>SM 10/10/22</i>	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3763-1 		Manufactured	No			110	Each	3.0000	1	4		<i>(4)</i> <i>SM 10/10/22</i>	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3763-1 		Manufactured	No			110	Each	3.0000	1	4		<i>(4)</i> <i>SM 10/10/22</i>	

Location	Loc Qty	Loc Code
ST251	3	
60499	3	

3

B61826 → (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

SHOP COPY

RELEASER

ENGINEERED

UNCONTROLLED DRAWING

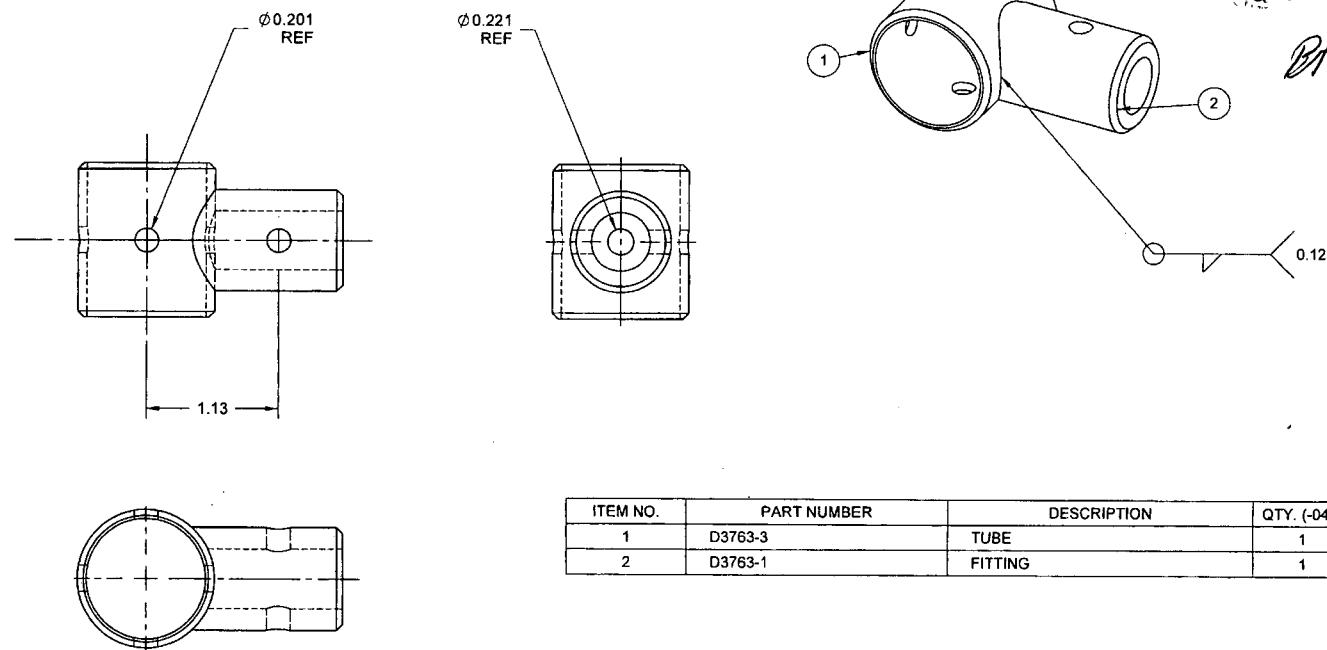
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORIGIN

NO. 62017

B10-95



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

D3763-041 END FITTING ASSY

RELEASED
060710MP

A NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL
3) TOLERANCE: AS OTHERWISE NOTED
4) UNITS: INCHES
5) BREAK: .010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A
8) WELD: PE

ASSEMBLY PER DART QSI 005 4.1
NOTED

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[initials]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[initials]</i>	D3763	SHEET 1 OF 9
APPROVED	<i>[initials]</i>	TITLE	SCALE
DE APPR.	<i>[initials]</i>	END FITTING	NTS
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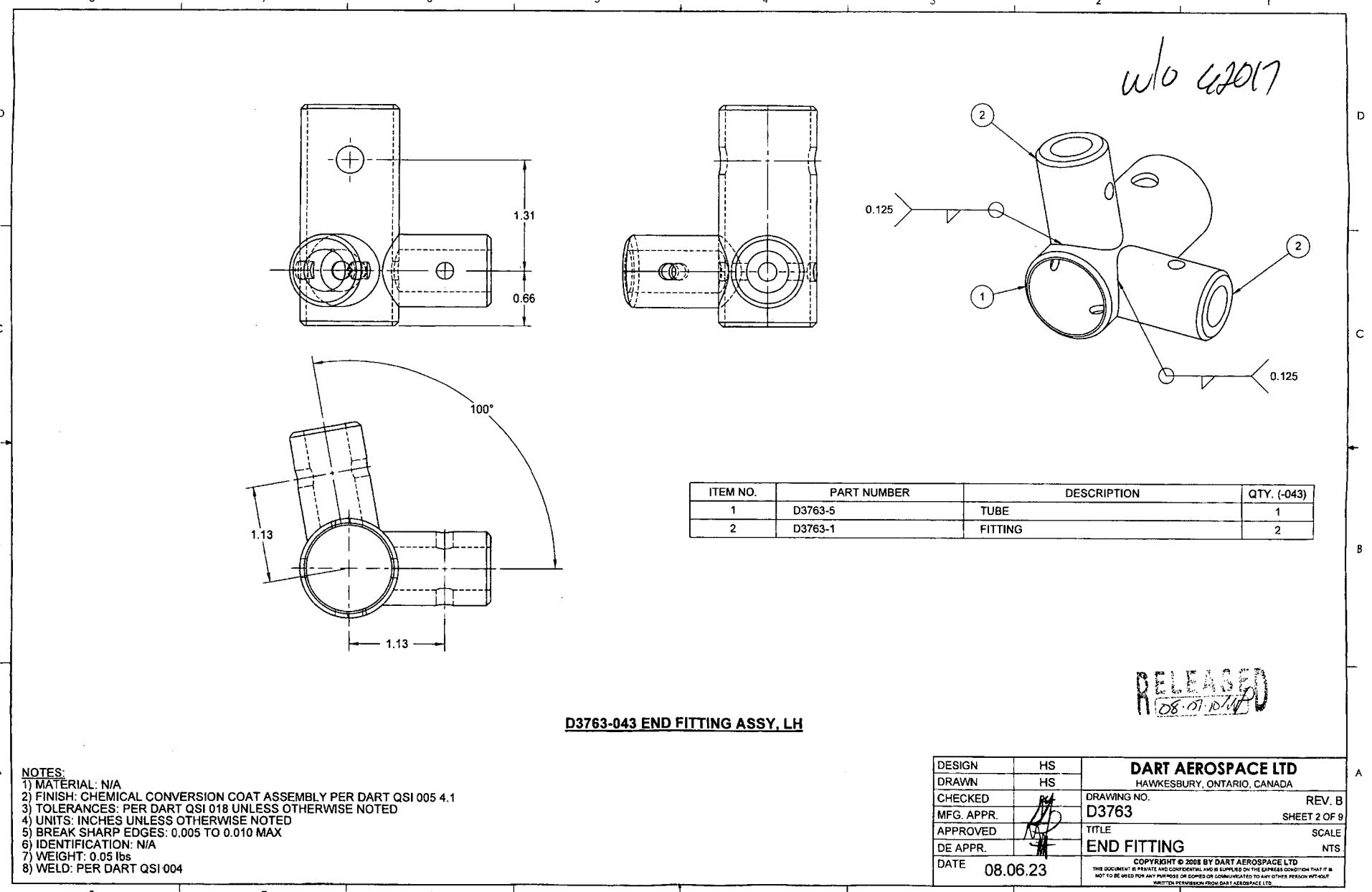
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NOTE: Date & initial all entries



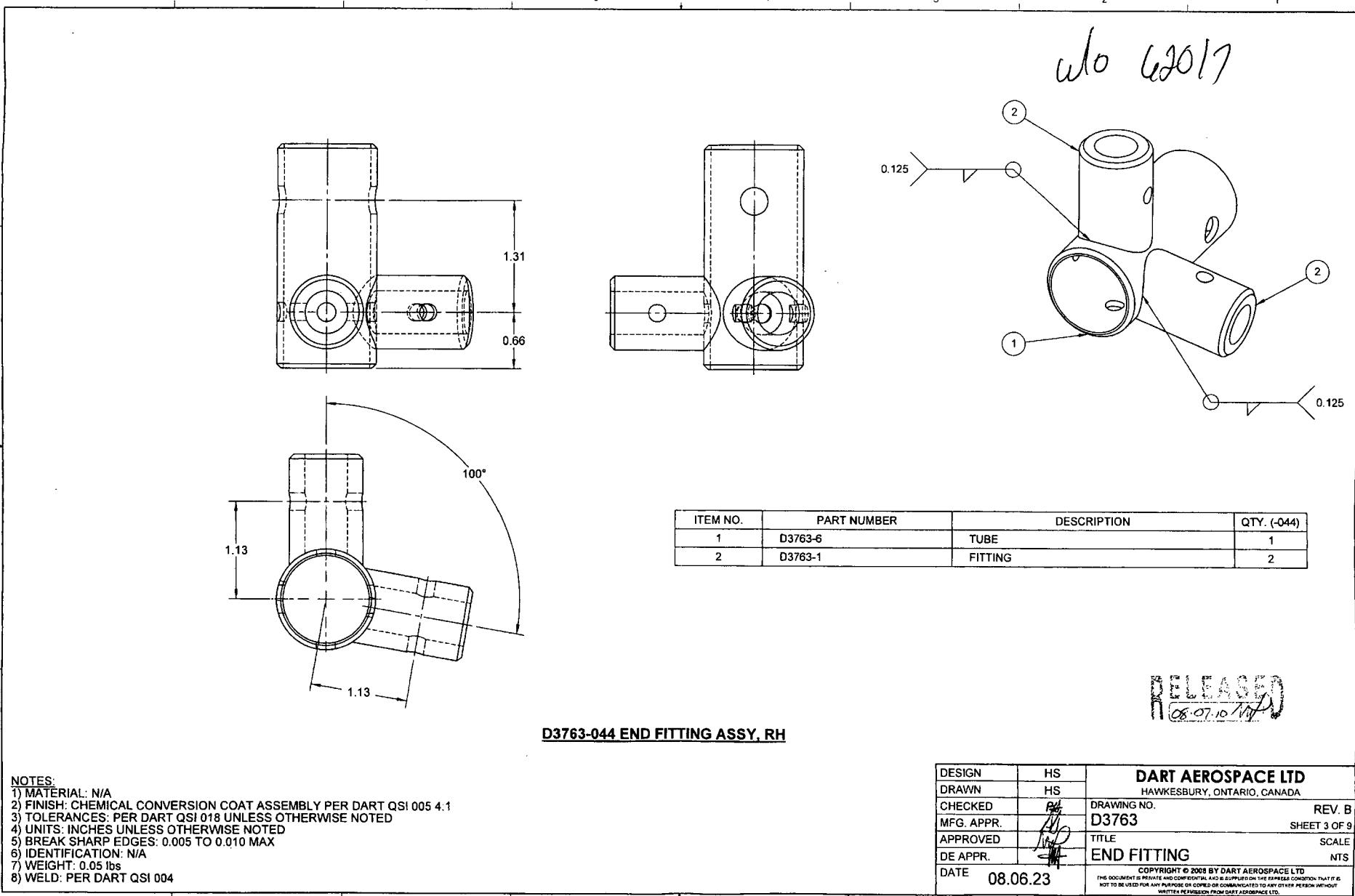
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3763-044 END FITTING ASSY, RH

DESIGN	HS	DART AEROSPACE LTD	
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CHECKED	PA	DRAWING NO.	
MFG. APPR.	AP	REV. B	
APPROVED	AP	D3763	
DE APPR.	AP	SHEET 3 OF 9	
DATE 08.06.23		TITLE	SCALE
END FITTING		NTS	

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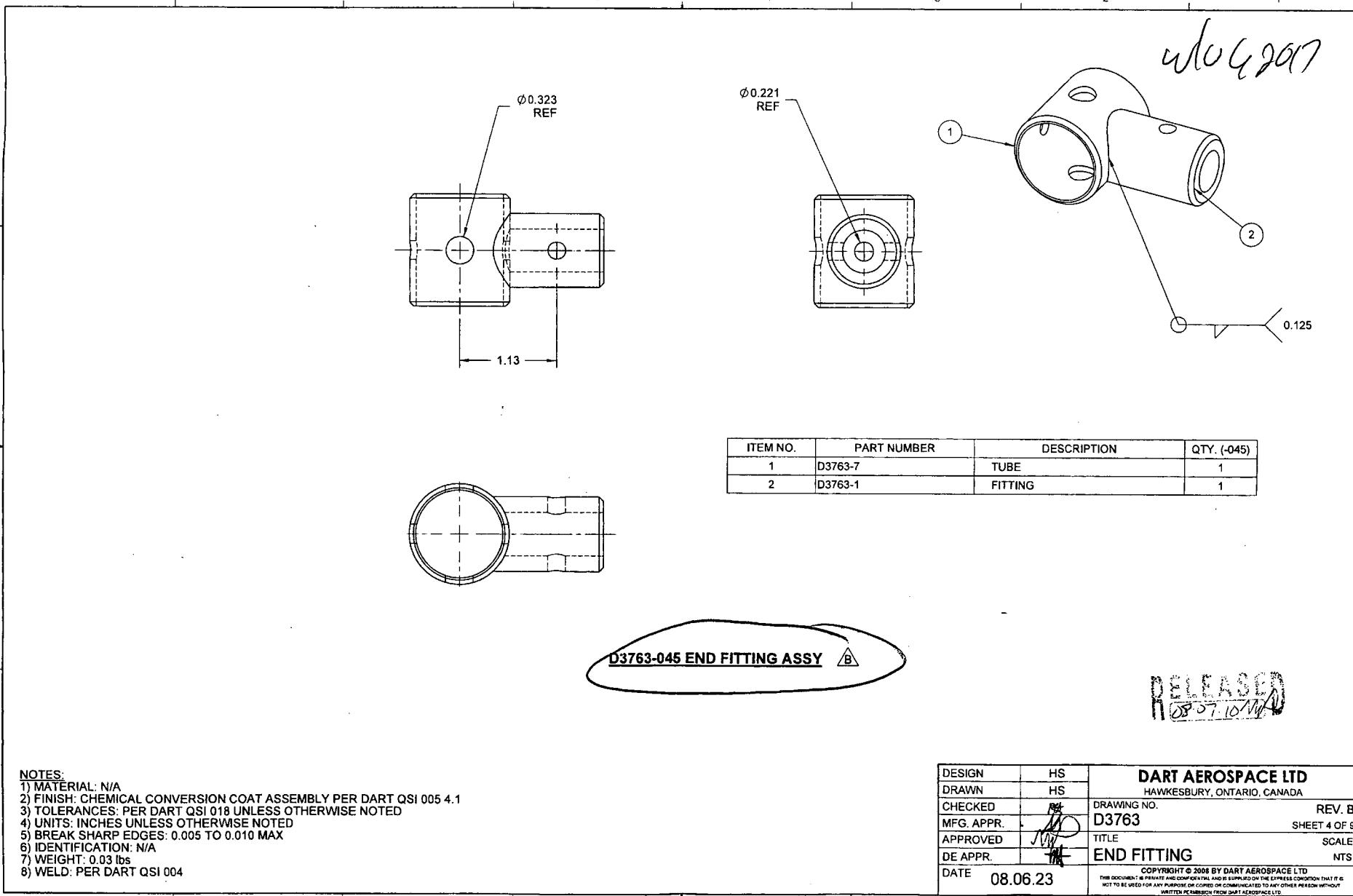
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
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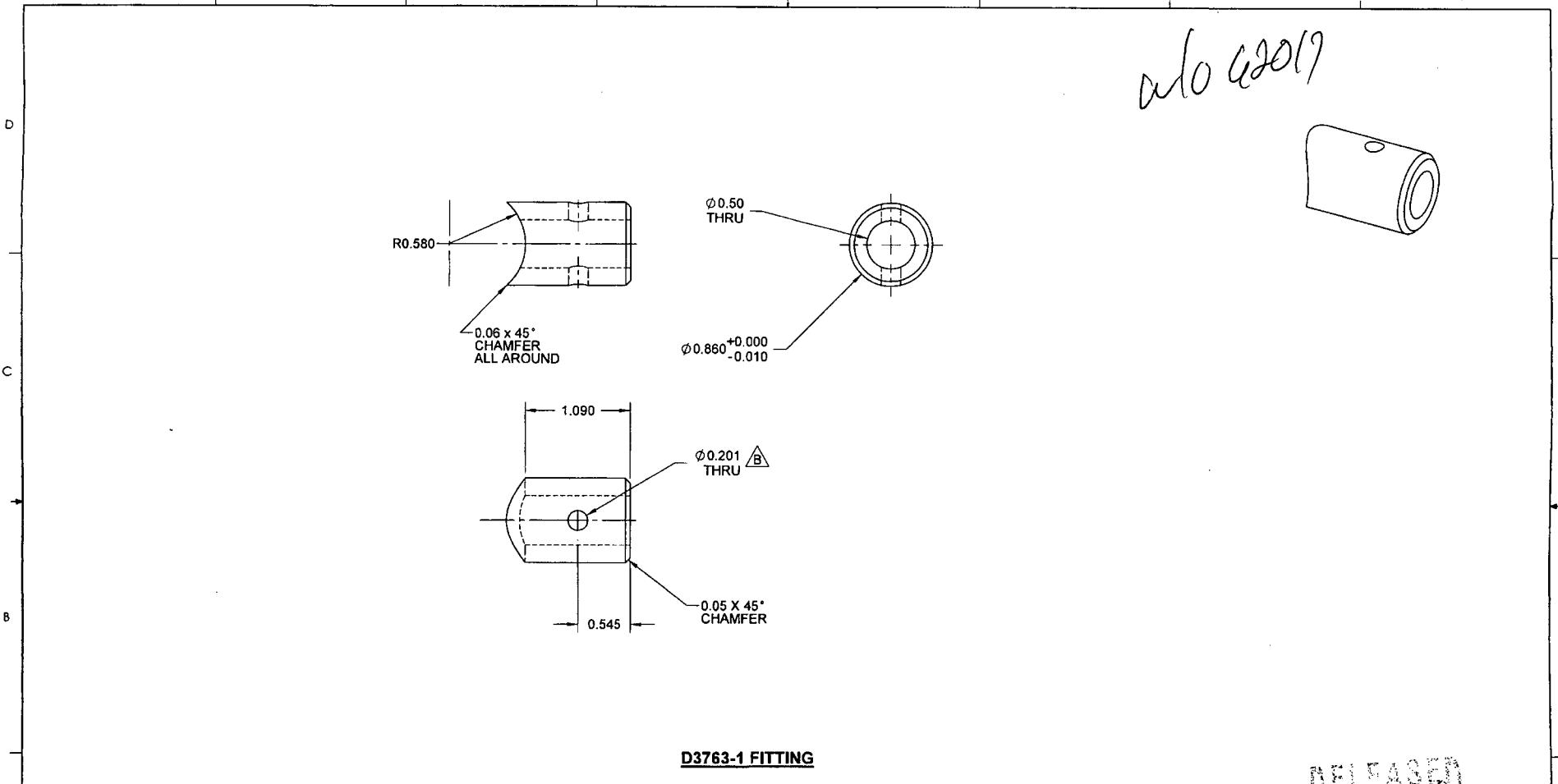
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3763-1 FITTINGRELEASED
08-07-10NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

8 7 6 5 4 3 2 1

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	M	DRAWING NO.	REV. B
MFG. APPR.	M	D3763	SHEET 5 OF 9
APPROVED	M	TITLE	SCALE
DE APPR.	M	END FITTING	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

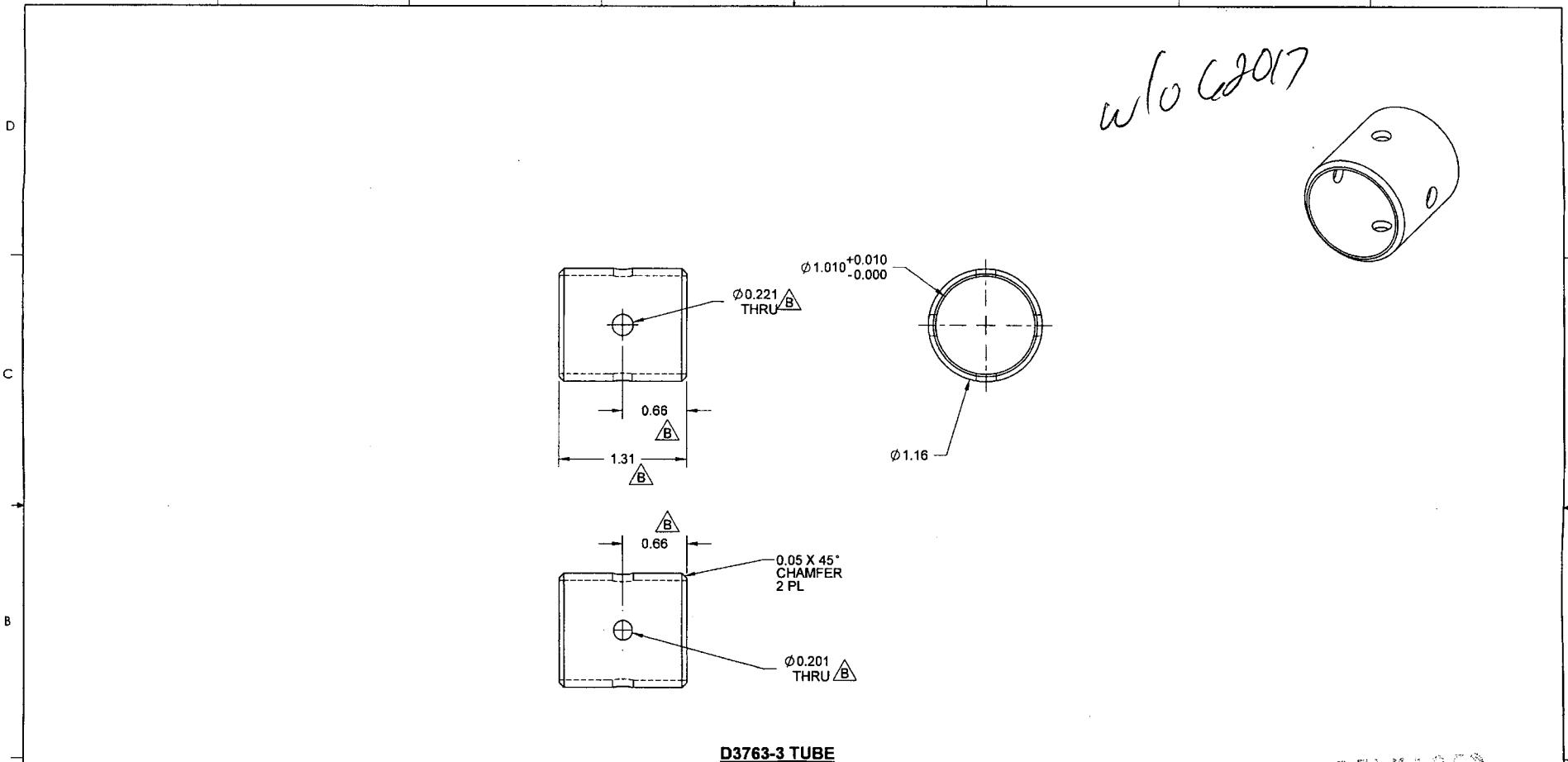
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3763-3 TUBE

RELEASER
08.07.10 MDA

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

8 7 6 5 4 3 2 1

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	
MFG. APPR.	<i>[Signature]</i>	D3763	REV. B
APPROVED	<i>[Signature]</i>	TITLE	SHEET 6 OF 9
DE APPR.	<i>[Signature]</i>	END FITTING	NTS
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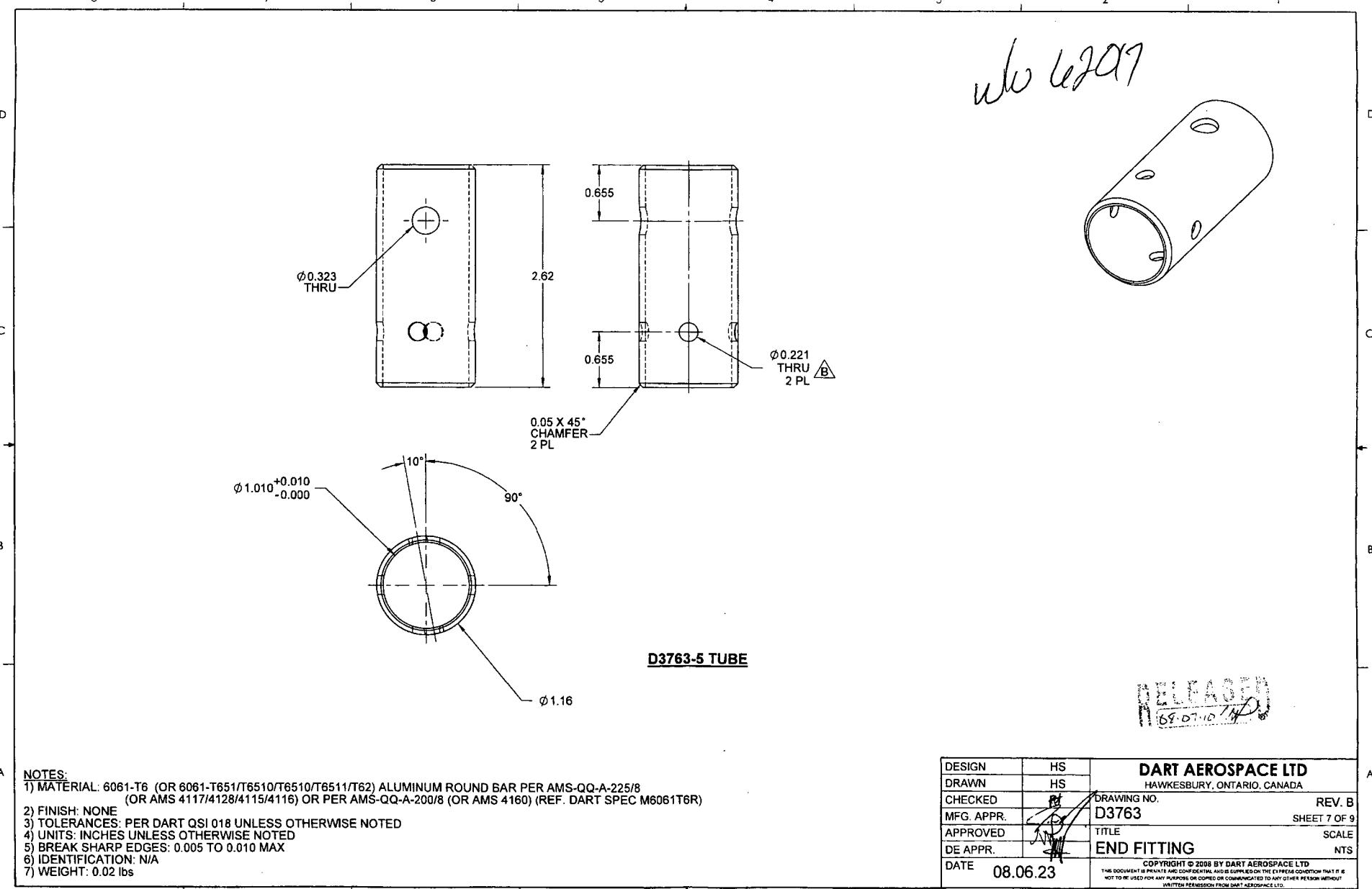
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

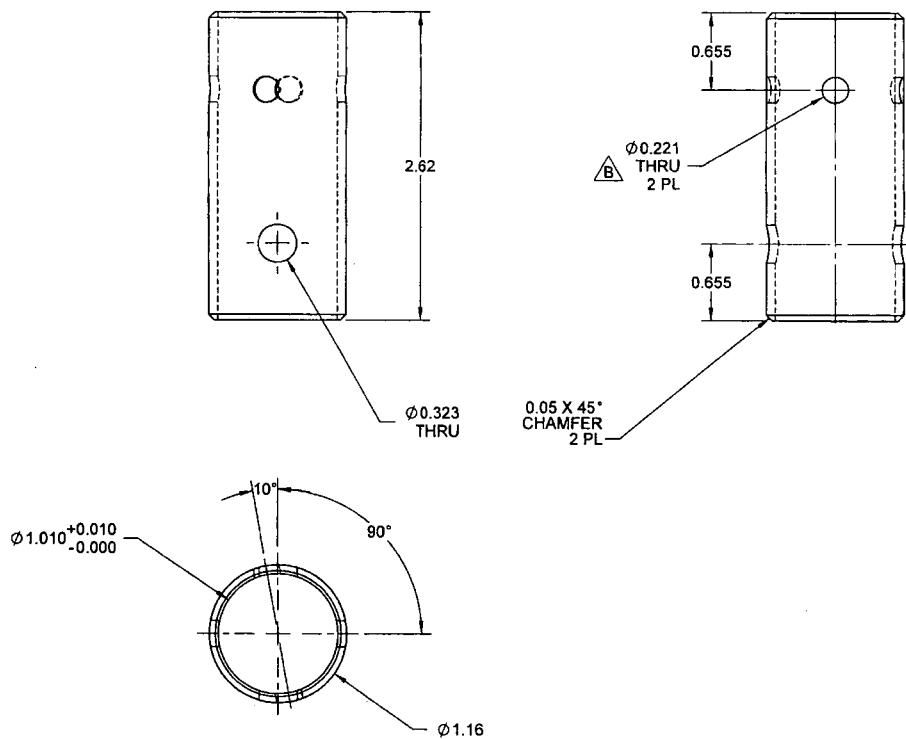
A

D

C

B

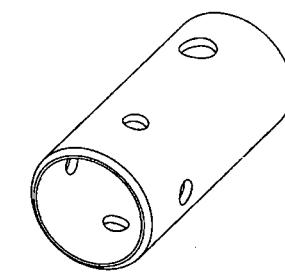
A

D3763-6 TUBENOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

8 7 6 5 4 3 2 1

W06209

RELEASED
08.06.2023

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SD</i>	DRAWING NO.	
MFG. APPR.	<i>SD</i>	D3763	REV. B
APPROVED	<i>SD</i>	TITLE	SCALE
DE APPR.	<i>SD</i>	END FITTING	NTS
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8 7 6 5 4 3 2 1

1

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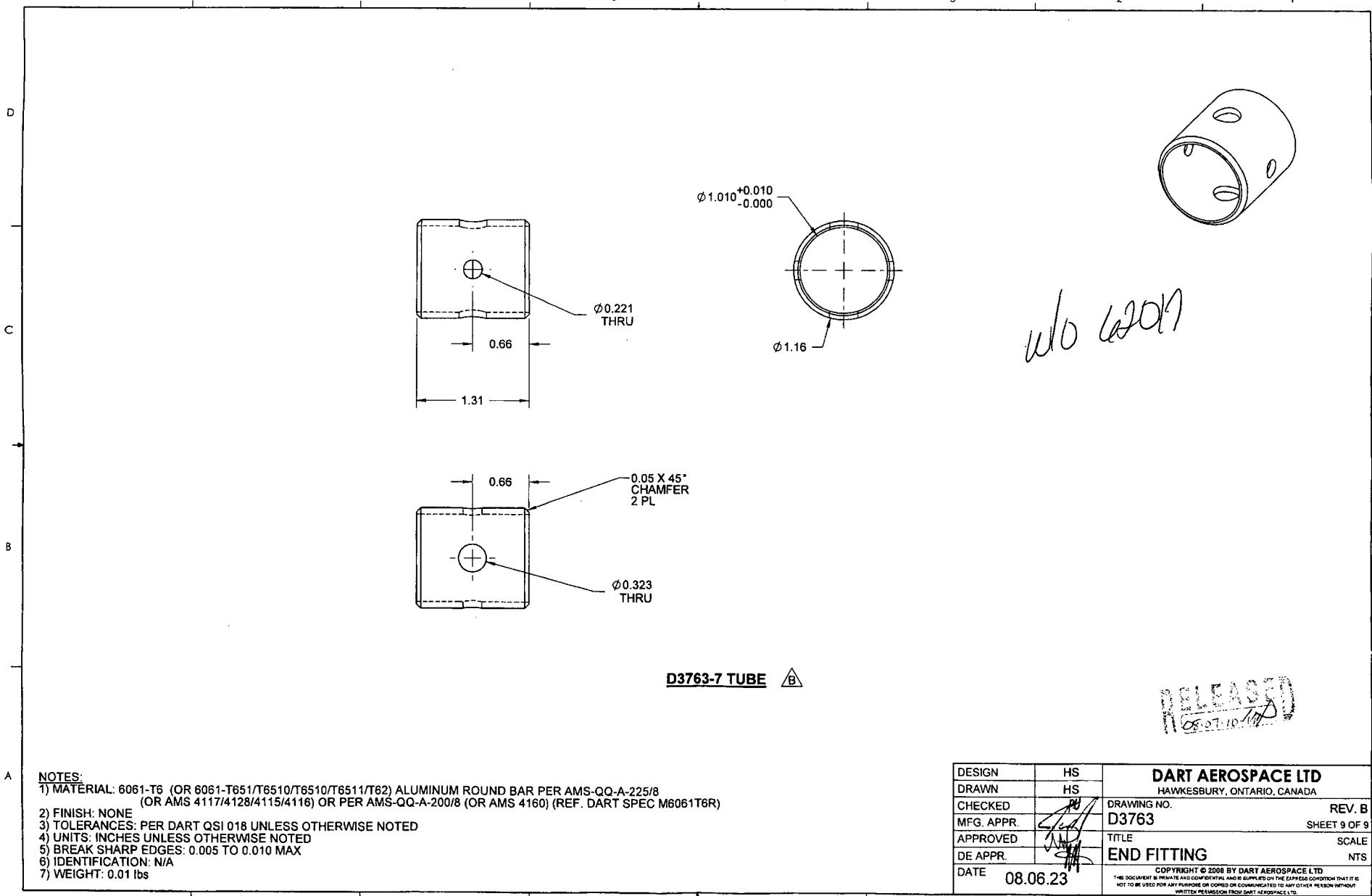
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

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